

Date: Wednesday, 5/16/2007 8:13:38 AM  
 User: Kim Johnston

## Process Sheet

SPLIT-1

23

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE  
 Job Number : 32379  
 Estimate Number : 10833  
 P.O. Number : N/A Part Number : D29331  
 This Issue : 5/16/2007 S.O. No. : N/A Drawing Number : D2933 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C  
 Previous Run : 32022 Material : N/A  
 Due Date : 6/6/2007 Qty: 16 Um: Each  
 Written By :  
 Checked & Approved By : J. J. O'S. 16  
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC  
 Est Rev: C As per Rev C 07-03-19 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6101001

7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: B31386

JML 07/06/25 4

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 &amp; attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 &amp; attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 &amp; attached Dimension Sheet

5-Deburr

JML/SA 07.06.26 (4)

3.0

MILLING CONV

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

JML/SA 07.06.26 (4)

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

JML/SA 07.06.26 (4)

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 32379

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J-F-07/06/27 (4)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 07/06/27 (2x)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

7/0: 4105 07/06/05 (4)

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

0-7/7/11 (1)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/12

Job Completion



u 07/07/12

QC14

07/07/12 (1)



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 32379
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2933-1
<b>Inspection Dwg:</b> D2933 Rev. C	Page 1 of 1

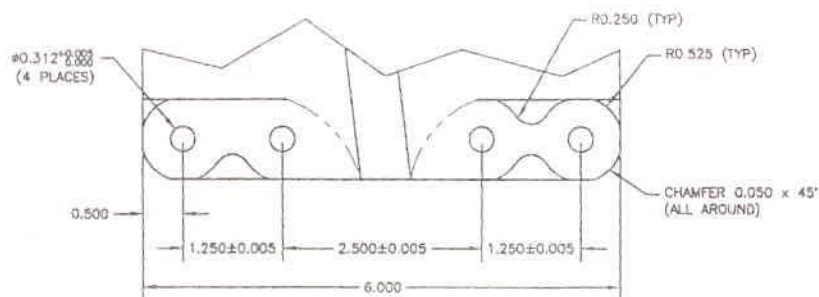
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.126	0.127	0.126	0.127		
B	0.100	0.140		0.127	0.126	0.124	0.127		
C	0.100	0.140		0.120	0.126	0.130	0.125		
D	0.210	0.230		0.224	0.225	0.224	0.224		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.501	2.501	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		0.126	0.126	0.126	0.125		
O	0.540	0.560		0.550	0.551	0.549	0.549		
P	0.490	0.510		0.502	0.496	0.498	0.496		
Q	3.715	3.725		3.717	3.719	3.719	3.719		
R	2.470	2.510		2.494	2.494	2.494	2.494		
S	0.240	0.270		0.252	0.254	0.254	0.254		
T	0.100	0.180		0.137	0.137	0.137	0.137		
U	1.625	1.635		1.631	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.136	1.136	1.136	1.136		
Y	1.565	1.585	DT8695 A/B	1.574	1.575	1.575	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	JML/SJA
Date:	07.06.26

Audited by:	J.F.
Date:	07/06/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	

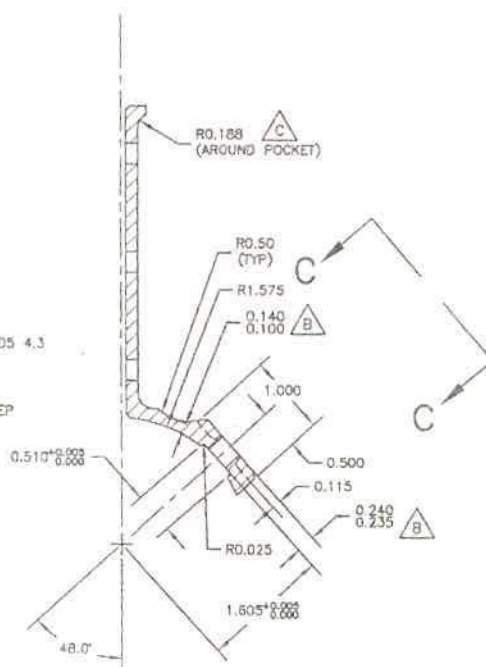


VIEW C-C

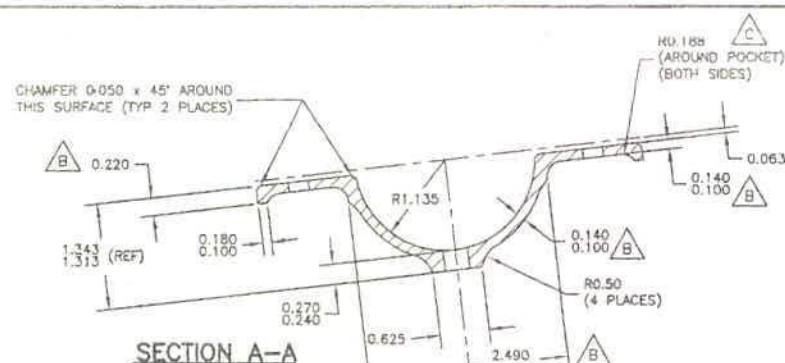
D2933-1 LH SADDLE (SHOWN)  
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

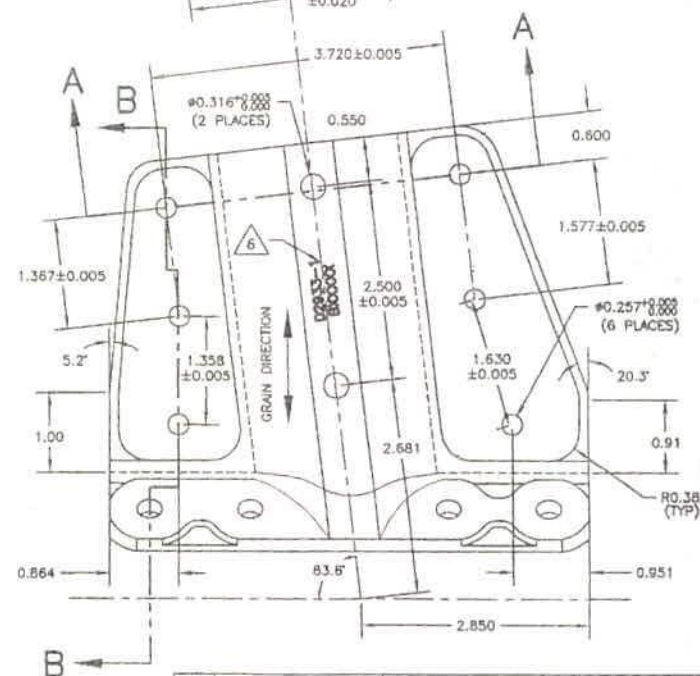
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	PH	DRAWING NO. D2933
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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07-02-12